

Work Order ID 74482

Page 1

Monday, October 03, 2011 10:28:43 AM

Item ID: D2662-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH In 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: MLJDate: 11/10/03

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2662

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.

Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB068 & DWG

DWG REV: DFOLIO REV: AA

11.10.19 10 1

SL

PTO

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

11.10.19 10 1

SL

W/O: 74482

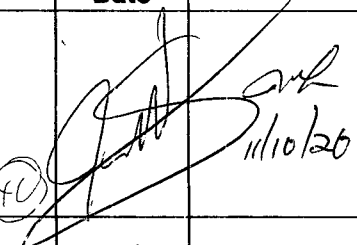
WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2662-2 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: HA Date: 11.10.25
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 11/10/25

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.10.19	110	T4H4 gauge R range down to .200" .010" below tol. program error that went uncorrected: two passes one per side	CP 11.10.19 QSON	High stress area. Scrap + replace 74769	 11/10/20		CP 11.10.19 QSON	S 11/10/20
		on the small bore were meant to be removed. RS operator forgot to take note + notify programmer. WOP	CP 11.10.19				CP 11.10.19	S 11/10/20

NOTE: Date & initial all entries

Work Order ID 74482

Monday, October 03, 2011 10:28:43 AM



Page 2

Item ID: D2662-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH In 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				10	1		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				10	1		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10	1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74482

Page 4

Monday, October 03, 2011 10:28:43 AM

Item ID: D2662-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH In 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/20
mf
11-1020

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 10:28:50 AM

Page 1

Work Order ID: 74482



Parent Item: D2662-2



Parent Item Name: Saddle, RH In 206

Start Date: 9/30/2011

Required Date: 10/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C□00.11.01□Removed P/O for Powder Coat - in house process□EC
IPP Rev:D As per Rev D 07-03-19 JLM □

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001

Manufactured

No

100

Each

4.0000

1

10



Saddle Billet

10 11.10.19

Location

Loc Qty

Loc Code

MAT040

4

66965

1

69677

2

73768

1

74482 ✓

10 + 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 744 82
Description: 206 Saddle, Inboard, Right side	Part Number: D2662-2
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.110	.121	.120	.120	.120	
B	0.100	0.140		.140	.137	.136	.137	.135	
C	1.125	1.145		1.142	1.137	1.136	1.137	1.137	
D	0.615	0.685		.685	.685	.685	.685	.685	
E	0.240	0.260		.241	.253	.253	.253	.252	
F	1.313	1.343		1.318	1.327	1.325	1.325	1.326	
G	0.210	0.230		.215	.222	.221	.221	.221	
H	0.100	0.180		.140	.140	.140	.140	.140	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.582	1.577	1.576	1.577	1.578	
K	0.235	0.240		.238	.238	.238	.238	.238	
L	0.100	0.120		.114	.114	.114	.114	.114	
M	0.990	1.010		.990	.990	.990	.992	.992	
N	0.510	0.515		.512	.512	.512	.512	.512	
O	5.990	6.010		5.997	5.996	5.997	5.997	5.997	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.313	.313	.313	.313	.314	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.792	.797	.796	.791	.797	
W	0.540	0.560		.548	.548	.548	.547	.549	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.257	.257	.257	.257	.257	
Z	0.912	0.932		.922	.918	.918	.923	.917	
AA	0.490	0.510		.498	.498	.499	.498		
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	11-10-19

Audited by:	<i>[Signature]</i>
Date:	11-10-19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74482
Description: 206 Saddle, Inboard, Right side		Part Number: D2662-2
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					Date
Dim	Min	Max	Go/No Go Gauge	16	27	38	49	By	
A	0.100	0.140		.140	.140	.140	.140	.140	
B	0.100	0.140		.125	.125	.125	.125	.125	
C	1.125	1.145		1.137	1.137	1.137	1.137	1.137	
D	0.615	0.685		.685	.685	.685	.685	.685	
E	0.240	0.260		.252	.252	.250	.257	.250	
F	1.313	1.343		1.325	1.325	1.325	1.325	1.325	
G	0.210	0.230		.221	.221	.221	.220	.221	
H	0.100	0.180		.140	.141	.140	.140	.140	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.577	1.578	1.577	1.577	1.577	
K	0.235	0.240		.238	.238	.238	.238	.238	
L	0.100	0.120		.114	.115	.115	.115	.115	
M	0.990	1.010		.993	.993	.991	.990	.990	
N	0.510	0.515		.572	.572	.572	.572	.572	
O	5.990	6.010		5.997	5.997	5.997	5.997	5.997	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.315	.315	.315	.315	.315	
S	0.315	0.322		.317	.317	.317	.317	.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.796	.795	.795	.795	.795	
W	0.540	0.560		.549	.549	.549	.549	.549	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.258	.258	.258	.258	.258	
Z	0.912	0.932		.917	.916	.917	.917	.915	
AA	0.490	0.510		.498	.499	.498	.497	.497	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>cmk</i>
Date: 11/10/20

Audited by: <i>[Signature]</i>
Date: 11.10.19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

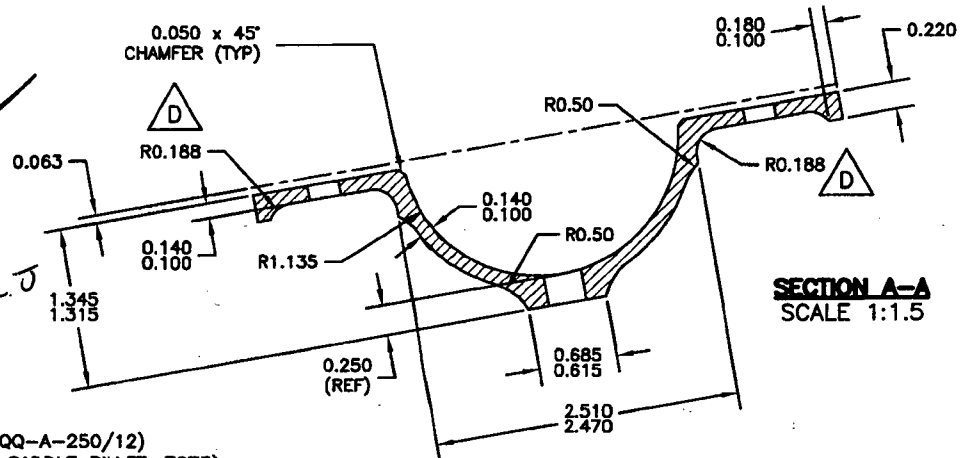
DART

DESIGN A	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE INSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

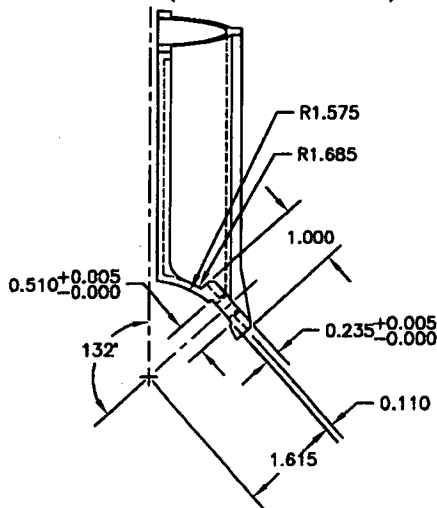
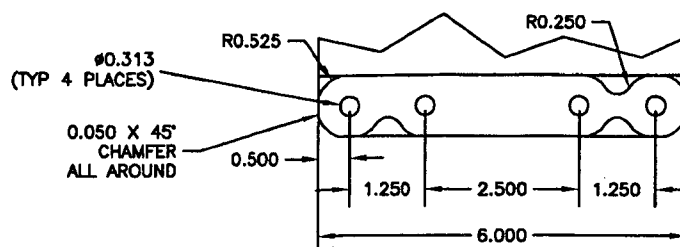
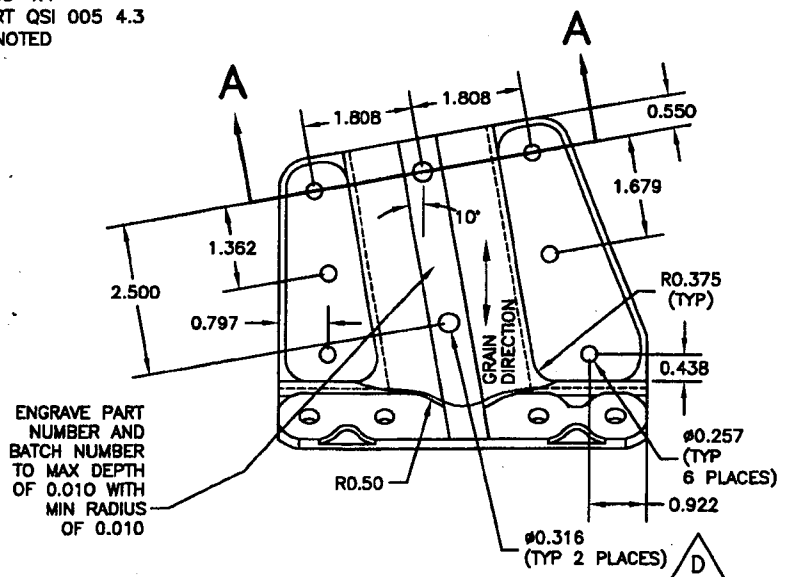
RELEASED

07.02.02

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **74402 M.L.O**
11/10/03

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)

**D2662-1 SADDLE INSIDE**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries